

Work Order ID 121525 - 1

121525

Page 1

Thursday, June 26, 2014 3:02:22 PM

Item ID: D4636-5

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 7/18/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 14-06-27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4636

D

100

100

Waterjet

FLOW CNC Waterjet

6061.040"

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

0.00

0.00

DAS

46

9-89

(128) / v 14/07/14

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

46

9-89

(128) / v 14/07/14

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

DAS

38

9-89

(128) / v 14/08/14

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Page 2

Item ID: D4636-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 7/18/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/18/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Counter sink

Memo

1- C'SINK HOLES AS PER DWG

0.00

0.00

DAS
30
9-89

30

14/08/14

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

30

DAS
38
9-89

14/08/15

14/08/15

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

30

14/08/18

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Item ID: D4636-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 7/18/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/18/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
						30	0	14-8-18.	DAS 34 9-89
170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:55 OVEN TEMPERATURE: 500 FINISH TIME: 1:25								
						30	0	14-8-18.	DAS 34 9-89
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
						30	0	14/08/18.	

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Item ID: D4636-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 7/18/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/18/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: ST112

0.00

190

Packaging

Memo

0.00

Packaging

30XDAS
28
9-89

AUG 18 2014

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 14-08-194-8-19

Picklist Print

Wednesday, July 09, 2014 11:28:36 AM

Page 1

Work Order ID: 121525

121525

Parent Item: D4636-5

D4636-5

Parent Item Name: Bracket

Start Date: 7/18/14

Required Date: 7/18/14

Start Qty: 120.00

Required Qty: 120.00

Comments:

IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC
13.07.17 AS PER DWG REV.C DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

127.7900

0.01

2

OK 14/09/14

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

127.79

m128422

49.79

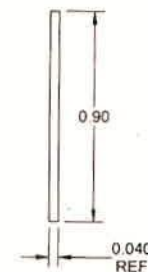
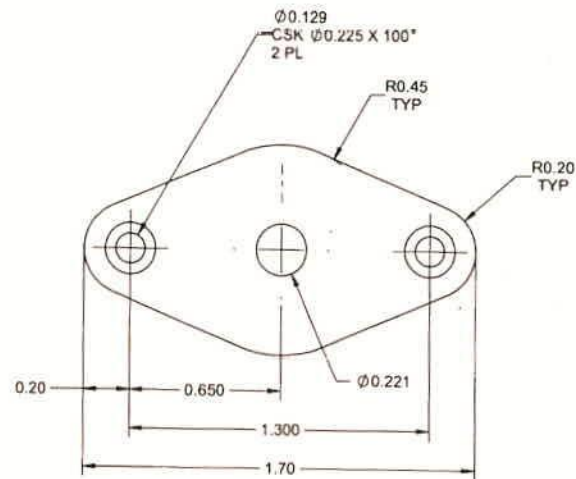
m129584

78

B127881

20

DAS
46
9-89



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 121525 ML5
406-27

D4636-5 BRACKET

RELEASED
2013-12-23
ADS

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.00 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO. D4636	REV. D
MFG. APPR.	BS		SHEET 4 OF 7
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BRACKET ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	